<b>Work Order ID 72170</b> <i>Tuesday, July 19, 2011 1:52:34 PM</i>											Page
Item ID: Revision ID:	D3558-3		1	Accept				s s	Setup Sta	rt	
Item Name:	Gasket 7/19/2011 7/25/2011	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	<b>D:</b>			Sto	p	
	Process Plan	n:	Date:	Tooling: SPC (Y/N):		ite:		R	tun Star Sto		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3558	Revis	sion Nbr B									
Waterjet FLOW CNC Waterjet		FLOW WATER JET  Memo  1-Cut as per Deburr if nec		0.00 0.00 Prog Rev:	) 1/07/25 ]			12			
110    <b>                             </b> QC		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	1/07/23	5		12		. <u> </u>	

120

QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

Quality Control

	•													
W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	IGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
								!						
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	s No	DQA:	Date: _						
Resolution:														
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (N	CR)								
DATE	STEP	Description of NC		Corrective Action Section B			erification	Approval	Approval					
DAIL	SIEF	Section A	Initial Action Descripti Chief Eng Chief Eng		Sig Da	n &	Section C	Chief Eng	QC Inspector					

#### Work Order ID 72170

Tuesday, July 19, 2011 1:52:34 PM



Page 2

Item ID:

D3558-3

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Gasket

**Start Date:** 

7/19/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

A	nn	rov	als:

Process Plan:

Date:

**Tooling:** 

Date:

Tool ID

Tool # Plan

Code

Run

Reject

Oty

Start

Stop



QC:

**Required Date: 7/25/2011** 

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Accept

Reject

Insp.

Stamp

Sequence ID/ Work Center ID

130

Packaging

Operation Description

Identify as per dwg & Stock Location: [P-N

Memo

Memo

0.00

0.00

**Qty** 

Number

Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dail Aci	ospace	LU						•		
W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			•							
Part No	•	PAR #:	Fault Category:NC			NCR: Yes No DQA: Date				
Resolution:			Dispositi	QA: N/C CI	osed:		Date: _			
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCF	R)				
DATE		Description of NC		on B	Verific	cation	Approval	Approval		
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign 8 Date	Section C		Chief Eng	QC Inspector	
				-						

#### **Picklist Print**

Tuesday, July 19, 2011 1:52:41 PM

Work Order ID: 72170

Parent Item:

D3558-3

Parent Item Name:

Gasket



Start Date: 7/19/2011

Required Date: 7/25/2011

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IDD Day A. Navy Ingua 06 12 15 H M

IPP Kev:A	new i	ssue	00-12-15 J	LM
Ets Rev:B	Rev B	dwg	07-12-06	DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	293.4900	0.7522	10.02933			_

NEOPRENE SHEET 0.063

Location Loc Code Loc Qty MAT052 293.49 55.68 237.81

	•													
W/O:			WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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									;					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQ.	A:	Date: _					
	Re	solution:	Dispositio	า:	QA: N/C	Clos	ed:		Date: _					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)								
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval				
DATE	SIEP	Section A	Initial Action Descri Chief Eng Chief Eng			gn & ate	Section C		Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	72170
Description: Gasket	Part Number:	D3558-3
Inspection Dwg: D3558 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.189		-	RA26	dum
0.30	+/-0.030	.290			RAZ6	Varn
0.30	+/-0.030	,290		-	N	
0.38	+/-0.030	.387	<u>ب</u>		RAZL	Vern
2.73	+/-0.030	2.74	)		RAOY	TADE
2.06	+/-0.030	2.08			((	4
5.63	+/-0.030	5,63			ı (	
33.75	+/-0.030	3375	_		9	
36.13	+/-0.030	36.13			y	
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		. '				
				11		
			al	1/1		

Measured by:	Audited by:	115	Prototype Approval:	N/A
Date: 1/07/28	Date:	11 07 25	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM 1.A	
В	08.04.17	Dimensions updated per Dwg Rev B	KJ/DD O	<u> </u>

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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		<u> </u>					·····							
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	.:	Date:						
	Resolution:			n:	_ QA: N/C CI	osed:		Date: _						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)								
DATE	OTED	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approvai					
DATE	STEP	Section A	Initial Action Descri Chief Eng Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector					
							<del></del>							
i.														
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		,												

<sup>\*</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT 8 WORK OF SER NO. 72/12 31.62 36.13 33.75 11.60 --28.13 6 EQ. SPACES 5 EQ. SPACES 5.63 PITCH 5.80 **5.63 PITCH** DETAIL A (TYP) - 0.38 0.38 -0.38 (TYP) 2.73 2.73 2.73 Ø0.19 R0.06 Ø0.19 2.06 (TYP 2 PLACES) -DETAIL A 2.06 DETAIL A R0.06 Ø0.19 **D3558-5 GASKET D3558-3 GASKET D3558-1 GASKET** (TYP 2 PLACES) 26.50 16.10 22.50 17.40 4 EQ. SPACES 5.50 PITCH 0.38 0.38 - 11.60 -DETAIL A (TYP) 0.38 -0.38 5.80 -DETAIL A Ģ 2.73 2.73 2.73 2.73 R0.06 R0.06 2.06 R0.06 2.06 2.06 DETAIL A Ø0.19 DETAIL A Ø0.19 Ø0.19 Ø0.19 **D3558-7 GASKET D3558-9 GASKET** D3558-11 GASKET **D3558-13 GASKET** R0.37 0.30 R0.11 (TYP) (TYP) 0.19 (REF) 0.75 ADD -9/-11/-13 07.04.20 UPDATE DRAWING FORMAT NOTES: Α NEW ISSUE PH 06.09.15 BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER 1) MATERIAL: DESCRIPTION BY DATE REV. (REF. DART SPEC. M-NEW60-S.063) 0.30 NONE DESIGN DART AEROSPACE USA, INC R0.38 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWN PORT HADLOCK, WA (TYP) 4) UNITS: INCHES UNLESS OTHERWISE NOTED CHECKED DRAWING NO. REV. B **DETAIL A** 5) BREAK SHARP EDGES: N/A D3558 SHEET 1 OF 1 (SCALE 1:2) MFG. APPR 6) IDENTIFICATION: NONE  ${\tt D3558-1-0.09\ lbs,\ D3558-3-0.26\ lbs,\ D3558-5-0.23\ lbs,}$ APPROVED TITLE SCALE 7) WEIGHT: **GASKET** D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs, DE APPR COPYRIGHT © 2007 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND COMPRENENT AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PARPOSE OR COMMANDATE TO ANY OTHER PERSON WITHOUT
WRITTER PRIVASION FROM DART ARROSPACE USA INC. D3558-13 - 0.06 lbs DATE 07.04.20

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В

8

SHOP COPY

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W/O:			W	ORK ORDER CHANG	GES		· · ·		
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	) <b>:</b>	PAR #:	Fault Cat	egory:	NCR: Yes	NCR: Yes No DQA: Date: _			
	Re	solution:	Dispositi	on:	QA: N/C CI	QA: N/C Closed:			
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE (NCR	()			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verification		Approval	Approval
	0.2		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector